






54399 Drew

Work Order ID 54071



November 26, 2009 1:51:03 PM



Page 1


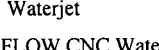
Item ID: D3442-1 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Shim
Start Date: 27/11/2009 Start Qty: 12.00  Cust Item ID:
Required Date: 03/12/2009 Req'd Qty: 12.00  Customer:
Reference:



Approvals: Process Plan: PL Date: 09-11-26 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____



Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3442	Rev A


100  FLOW WATER JET 0.00
Waterjet  Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3442 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

HB9-12-2  Last page


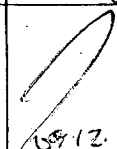

110  QC2- Inspect parts off machine FAI/FAIB 0.00
QC  Memo 0.00
Quality Control

HB9-12-2



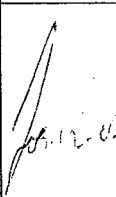
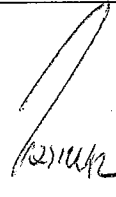
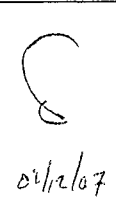
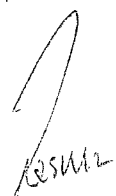
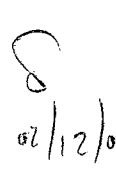
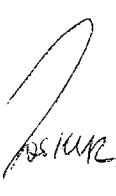

120  QC8- Inspect parts - second check 0.00
QC  Memo 0.00
Quality Control

27 801/12/07  18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
01-12-07	100	See NCR below: Perm. Change Rolls correct inch thickness.	N/A			 01/12/07	 02/12/07	
		PAR10-005 PAR10-007	REFERENCE ONLY					

Part No: D3442-1 PAR #: N/A Fault Category: Eng - Dwg NCR: Yes No DQA: A Date: 10.01.21
 Resolution: Acceptable Disposition: Use-as-is QA: N/C Closed Date: _____

NCR: 54071		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/07	100	Fans st inspection that w/o calls for m30452219A but Dwg calls for m3045219A B.C. w/o not correctly updated		- contact w/o + Bom. - add copy of new Bom for Reference open for N/A Dwg thickness in inches is good.	N/A  01/12/07	 01/12/07	 01/12/07	 01/12/07
		from m3045219A		- Prints acceptable & correct correct mat'l thickness	B 9-12-07	 02/12/07	 02/12/07	 02/12/07
			REFERENCE ONLY					

NOTE: Date & initial all entries

November 26, 2009 1:51:03 PM



Accept

**Setup Start**

Stop

**Cnst Item ID:**

[REDACTED]

Customer:

Reference:

Run Start

**Approvals:**

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00				18x			
Small Fab	Memo	0.00	= 7 m-d 09/12/07						
Small Fab	Deburr if necessary.								
140	QC5- Inspect part completeness to step on W/O	0.00				4/6			
QC	Memo	0.00	275 09/12/07						
Quality Control									
150	Identify as per dwg & Stock Location: <u>Basket</u>	0.00				PD	09.12.08		(12)
Packaging	Memo	0.00							
Packaging									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November 26, 2009 1:51:03 PM



Accept

**Setup Start**

Stop

**Cust Item ID:**

[illegible]**Customer:**

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/08

MF 09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 26, 2009 1:51:10 PM

Page 1

Work Order ID: 54071

Parent Item: D3442-1RevA

Parent Item Name: Shim

Comments:

Start Date: 27/11/2009

Required Date: 03/12/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S22GA

Purchased

No

100

sf

35.1500

0.5053

18



HB 9-12-2

304/316 .032 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

35.15

109023

32.45

109088

2.7

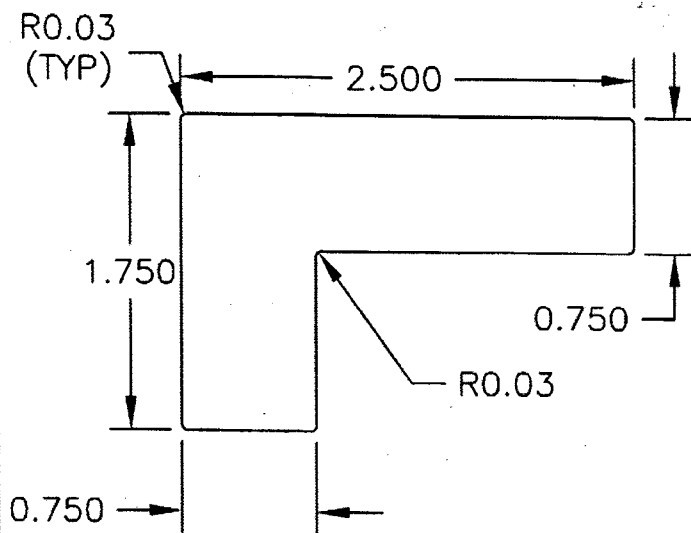
109057

109057

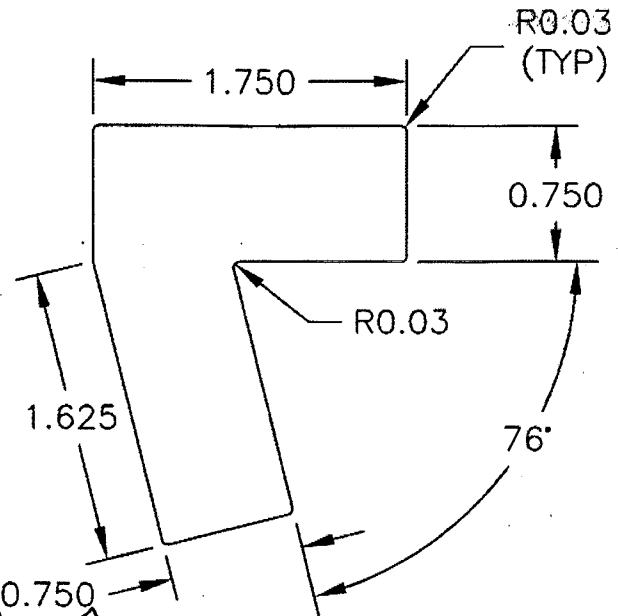
(18)

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03	TITLE SHIM	SCALE 1:1	
A	05.06.03	NEW ISSUE	

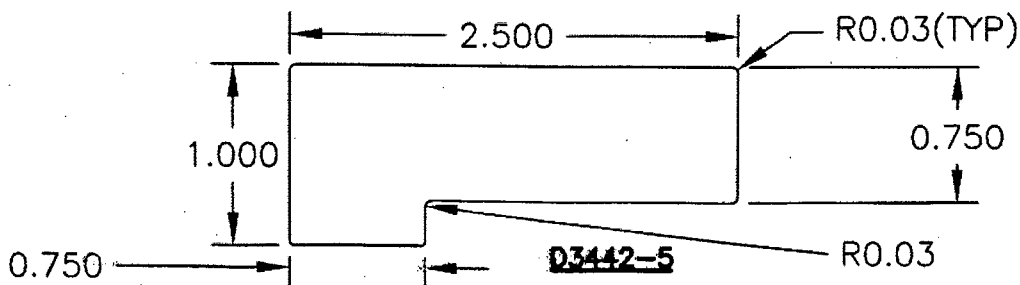
**D3442-1****D3442-1/-3 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3442-3**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54071

09-11-24

**D3442-5****D3442-5 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.08.19 *[Signature]*

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